Quality Control

100591

Page 1

Wednesday, April 24, 2013 9:02:58 AM Item ID: D3136-043 Accept *N900040100* Setup Start **Revision ID:** Item Name: Window Assembly **Start Date: Start Qty: 16.00** 4/24/2013 **Cust Item ID:** Required Date: 5/9/2013 Req'd Qty: 16.00 **Customer:** Reference: Run Process Plan: Approvals: Tooling: Date: Stop QC: Date: SPC (Y/N): Date: Sequence ID/ Operation Set Up/ Reject Tool ID Tool # Plan Accept Reject Insp. Work Center ID Description **Run Hours** Code Qty Qty Number Stamp **Draw Nbr Revision Nbr** D3136 Rev E 100 0.00FLOW WATER JET *100* Waterjet 0.00 Memo FLOW CNC Waterjet 1-Cut as per Dwg Dwg Rev: Plexiglass G 125" Prog Rev: 110 QC2- Inspect parts off machine FAI/FAIB 0.00 *110* JM 13-5-2 0.00 Memo Quality Control 120 QC8- Inspect parts - second check 0.00 0.00 Memo

												DQA: _	Date:	
NCR: Y	es ,	/ N	o				WORK ORDER NON-C	ON	IFORN	//ANCE / UP	DATE		-	
										2.1.0		QA Closed:	Date:	
Work Orde	or.						DISPOSITION				AGAINST DE	PARTMENT/	PROCESS	
Part N	_						Rework Scrap Use-as-is		ľ	Skid-tube Machining noforming	Crosstube Small Fab Finishing		Water Jet I. Eng. Coor. e/Packaging	Engineering Quality Other
NCR N	10						Work Order Update			Large Fab	Composite]	Supplier	
Root						Descri	ption of work order update	11	nitial	Ac	ction	Sign &		
Cause		Dat	e	Step	Qty	(or Non-conformance	Ch	ief Eng	Desc	cription	Date	Verification	QC Inspector
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		rack	S				Broken/Damaged	Ш	Inspecti	on Incomplete		Part Incorred		Weld
i		rush	ed/C	rimped.			Burrs	Ш	Instruct	ions Incomplete,	/Unclear	Part Lost/Mi	ssing	Wrong Stock Pulled
	C	uffs					Contamination	Ш	Mainte	nance		Part Moved		
	}	leat	Treat				Countersink		Mislabe	led		Positioned V	_	_
		rspe	ction	Strip in	Tube		Cut Too Short		Misread	l		Power Loss/	Surge	Other
	R	ipplé	es in	Bend			Drill Holes		Offset					
	Ī	orqu	e Wa	aves in E	xtrusio	n 🗌	Drawing		Out of 0	Calibration				
	T	urni	ng Se	quence			Finish		Out of S	Sequence				
	V	Vave	/Twi	st in Tuk	ре		Folio		Outside	Dimensions				

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140

140

HAND FINISHING THERMOFORMING

(D3136-3)

Thermoform Memo

Thermoforming Machine

0.00

3- Engrave Part # and Batch #, and affix labels

Water sand and buff to remove scractches as required

0.00

Insp.

Page 2

Work Orde	lo	No 				DISPOSITION Rework Scrap Use-as-is Work Order Update	COI	l Thern	Skid-tube Machining noforming Large Fab			Date:	
NCR N						Work Graci Spaate						12 12	
Root						ption of work order update	ł	Initial		tion	Sign &		
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Other Process	-												
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Landin	ng Gear	1				General	AUL	LICAIL	JONI				
Landir	Bend Cent	re No	ot Concer	ntric to (D/S	Bend BOM/Route		Grain Hardwa			Ovalized Over/Under	 	Pressure/Forced Temperature/Cure
	Crack Crust		Crimped.		-	Broken/Damaged Burrs		-1	ion Incomplete ions Incomplete/	'Unclear	Part Incorre Part Lost/M	 	Weld Wrong Stock Pulled
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H:/FORMS/Quality Assurance\approved QA/NCRWO Rev G

100591

Page 3

Wednesday, April 24, 2013 9:02:58 AM Item ID: D3136-043 Accept *N900040100* Setup Start **Revision ID:** Item Name: Window Assembly **Start Qty: 16.00 Start Date:** 4/24/2013 **Cust Item ID:** Req'd Qty: 16.00 Required Date: 5/9/2013 **Customer:** Reference: Run **Process Plan:** Approvals: Date: **Tooling:** Date: Stop QC: SPC (Y/N): 🔎 🦠 Date: Date: Operation Sequence ID/ Set Up/ Reject Tool ID Tool # Plan Accept Reject Insp. Work Center ID Description Run Hours Code Qty Qty Number Stamp 150 QC2- Inspect parts off machine FAI/FAIB 0.00 *150* QC 0.00 Memo Quality Control 170 QC5- Inspect part completeness to step on W/O *170* Memo Quality Control Inspect edge and window deformation, wrap in plastic Identify as per dwg & Stock Location: 180 *120* Packaging 0.00 Memo **Packaging**

NCR:	Yes	/ N	0				WORK ORDER NON-C	100	NFORI	MANCE / UPDATE	,	DQA:	Date Date	10/1/0
Mork Orde	nr:	10	100	-91			DISPOSITION			AGA	INST DE	PARTMENT	/PROCESS	
I	No.	D	313	36-c 25/1		S	Rework Scrap Use-as-is Work Order Update			Skid-tube Cross Machining Smal noforming Finis Large Fab Compo	l Fab	4	Water Jet d. Eng. Coor. re/Packaging Supplier	C Engineering Quality Other
Root							ption of work order update		Initial	Action		Sign &		
Cause		Dat	e	Step	Qty		or Non-conformance		ief Eng	Description		Date	Verification	QC Inspector
Doc/Data Equip/Tooling Operator Material Setup Other Process Supplier Training Unapproved	<u>*</u>	13/65	А	# 170	46	Or el Novy He	At inspecting that working have /crader on case in leasons on to each other/	۵>	16, 16, 1,012	SCHAP + DSM.		13/oslota.	Blost	0AS 16 26 07\$ 042 13/05/07
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	_	Inspec Ripple		Strip in Bend	Tube	-	Cut Too Short Drill Holes		Misread Offset	1	<u> </u>	Power Loss/		Other Odei
	\vdash	,				⊢	4	 	√			True W	THE CELL TO	V

Out of Calibration

Out of Sequence

Outside Dimensions

Turning Sequence

Wave/Twist in Tube

Torque Waves in Extrusion

Drawing

Finish

Folio

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Quality Control

Wednesday, April 24, 2013 9:02:58 AM Item ID: D3136-043 Accept *N900040100* Setup Start **Revision ID:** Item Name: Window Assembly **Start Date:** 4/24/2013 **Start Qty: 16.00** Cust Item ID: Required Date: 5/9/2013 Req'd Qty: 16.00 **Customer:** Reference: Run Approvals: **Process Plan:** Date: Tooling: Date: Stop QC: SPC (Y/N): Date: Date: Sequence ID/ Operation Set Up/ Tool ID Tool # Plan Accept Reject Reject Insp. Work Center ID Description Code Qty Number Stamp Run Hours **Qty** 190 QC21- Final Inspection - Work Order Release 0.00 *190* MLJ 1305-06 WF (3-5-6 0.00 Memo

NCR:	Yes /	No				WORK ORDER NON-	CONF	FORM	//ANCE / UP	PDATE	QA Closed:	Dat	to:	
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Work Ord	ar.					DISPOSITION				AGAINST DE	PARTMENT	/PROCESS		
WOIK OIG	·· —					Rework	7 J		Skid-tube	Crosstube	1	Water Jet	Engineering	
Part I	Vο					Scrap	1 1		Machining	Small Fab	Pro	d. Eng. Coor.	Quality	
	···—	- -	-,			Use-as-is	┨ .		noforming	Finishing	4	re/Packaging	Other	
NCR I	No.					Work Order Update	1		Large Fab	Composite		Supplier		
						,			- <u>-</u>		4	•		
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Operator	Ш	i												
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Unapproved		<u> </u>	<u> </u>				<u> </u>							_
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		ł	ot Conce	ntric to	o/s	BOM/Route	——	ardwa			Over/Under		Temperature/Cure	
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	Cru	ish <mark>ed/</mark>	Crimped		_	Burrs	∐ lr	nstruct	ions Incomplete,	/Unclear	Part Lost/M	issing	Wrong Stock Pulled	
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	l wa	ve/Tw	ist in Tul	ne .		Teolio	\Box_0	utside	Dimensions		<u> </u>			

DQA: Date:

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Wednesday, April 24, 2013 9:02:57 AM

Work Order ID:

100591

Parent Item:

D3136-043

Parent Item Name:

Window Assembly

Start Date: 4/24/2013

Required Date: 5/9/2013

Start Qty: 16.00

Required Qty: 16.00

Comments:

IPP Rev:A04.02.04New issueKJ/DS

IPP Rev.B 07.05.29

Thermoform in-house DL

IPP rev C 07.09.28 Rev E dwg

EC verified by:DD IPP Rev:D 10.06.24 added note in qc5

seq	170	DD	verf:EC
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	seq 170 DD vert:E	EC .										
Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Status Issued
D3108-9 Decal	•	Manufactured	No			100	Each	504.0000	2	32		Sh
				Location		Loc Qty	Lo	oc Code				13/05/06
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				345		26			/			
*** 004 - 00				465	46	478				32.4		,
MACRLICS.125 1/8" Polycast II Sheet		Purchased	No			170	sf	621.7445	3.9	87.A .60	Fall of American (1)	Jm13-5-2
				Location		Loc Qty	Lo	c Code				
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				123	704	33						
				123		71						,
				124	559	174			190	SS ⁹		
				ther		343.7445						
				123	895	343.7445						

NCR: Y	es / N	10				WORK ORDER NON-O	CONFOR	MANCE / UP	DATE	0461	Data	
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Work Orde	r·					DISPOSITION			AGAINST DE	PARTMENT	/PROCESS	
Work Orde	'·	1				Rework	1 	Skid-tube	Crosstube]	Water Jet	Engineering
Part N	0.					Scrap	1	Machining	Small Fab	Pro	d. Eng. Coor.	Quality
						Use-as-is] Therr	moforming	Finishing	Rec/Sto	e/Packaging	Other
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	Crack	 				Broken/Damaged	—	tion Incomplete	1	Part Incorre	<u> </u>	Weld
	Crush	ed/Crir	nped.			Burrs		tions Incomplete/	'Unclear	Part Lost/M	issing	Wrong Stock Pulled
	Cuffs				L	Contamination	\vdash	enance		Part Moved		
	Heat	reat				Countersink	Mislab	eled		Positioned \		¬
	Inspe	ction St	trip in	Tube		Cut Too Short	Misrea	d		Power Loss,	'Surge	Other
1	Rinnle	s in Re	nd			Drill Holes	Offset					

Out of Calibration

Out of Sequence

Outside Dimensions

DQA:

Date:

H:/FORMS/Quality Assurance\approved QA/NCRWO Rev G

Turning Sequence

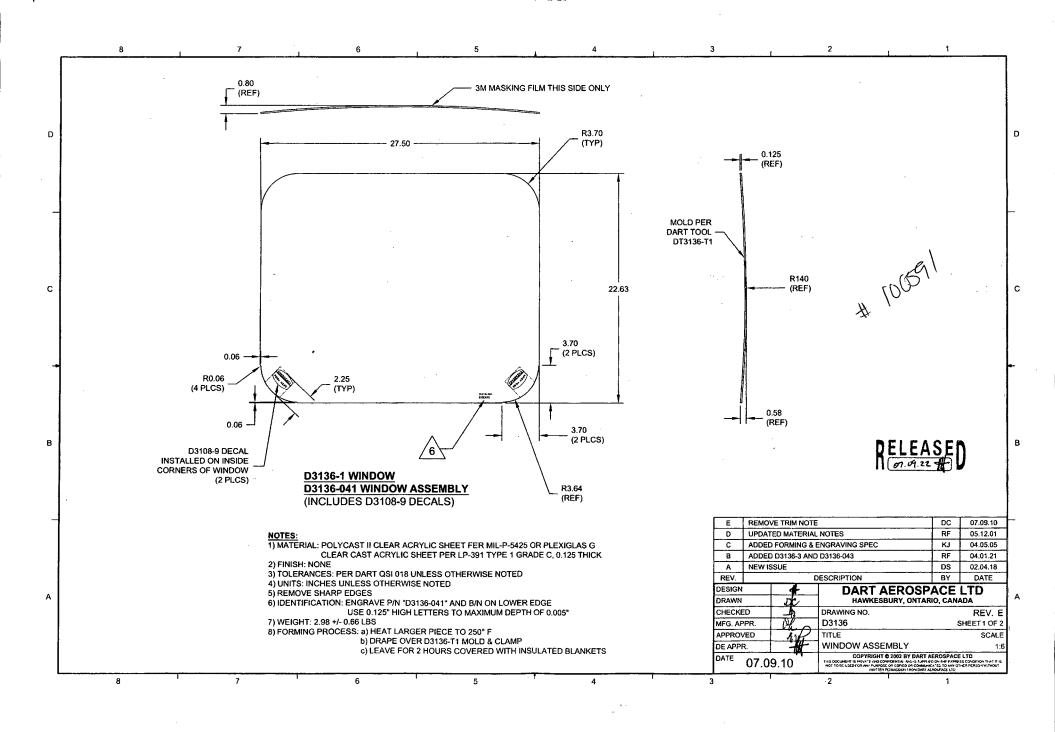
Wave/Twist in Tube

Torque Waves in Extrusion

Drawing

Finish

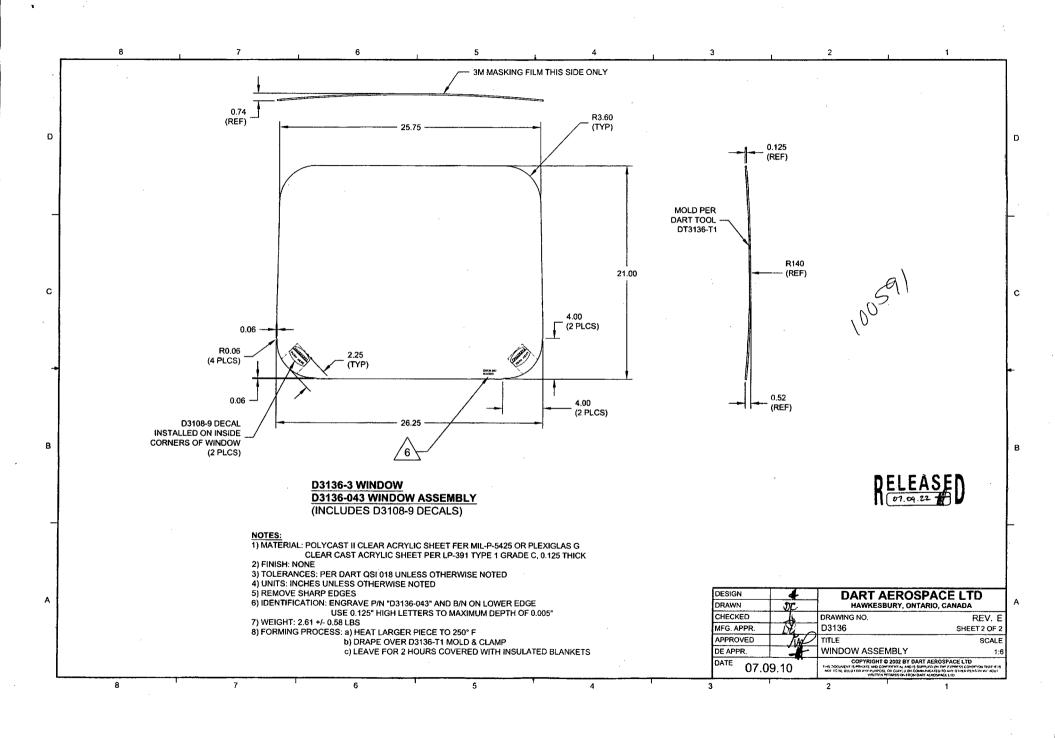
Folio



NCR: Y	es / No				WORK ORDER NON-O	CONF	ORN	MANCE / UP	PDATE	QA Closed:	Dat	e:
Work Orde	er:			 	DISPOSITION			1 212 4	AGAINST D	EPARTMENT	/PROCESS	
Part N					Rework Scrap		ſ	Skid-tube Machining	Crosstube Small Fab		Water Jet d. Eng. Coor.	Engineering Quality
NCR N	No.				Use-as-is Work Order Update			noforming Large Fab	Finishing Composite	Rec/Sto	re/Packaging Supplier	Other
Root				Descri	ption of work order update	Initi	al	Ad	ction	Sign &		
Cause	Date	Step	Qty	,	or Non-conformance	Chief	Eng	Desc	cription	Date	Verification	QC Inspector
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ĺ	Crushed	/Crimped	•		Burrs	Ins	truct	ions Incomplete	/Unclear	Part Lost/M	issing	Wrong Stock Pulled
	Cuffs				Contamination	Má	ainte	nance	Ĺ	Part Moved		
	Heat Tre	at			Countersink	Mis	slabe	led	L	Positioned \	Wrong	
	Inspection	on Strip in	Tube		Cut Too Short	Mis	sreac	i		Power Loss,	/Surge	Other
	Ripples i	n Bend			Drill Holes	Off	set			***		A Section Co.
Ī	Torque \	Waves in E	xtrusio	n [Drawing	Ou	t of (Calibration				
	Turning	Sequence			Finish	Ou	t of S	Sequence			<u> </u>	
ļ	Wave/Tv	wist in Tul	ре		Folio	Ou	tside	Dimensions				

DQA: Date:

H:/FORMS/Quality Assurance\approved QA/NCRWO Rev G



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Work Orde	·r·						DISPOSITION				AGAINST I	DEPA	RTMENT	/PROCESS	
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Part N	lo.						Scrap	1	1	Machining	Small Fab	\exists	Pro	d. Eng. Coor.	Quality
	_						Use-as-is		Therm	noforming	Finishing		Rec/Stor	e/Packaging	Other
NCR N	lo						Work Order Update	J		Large Fab	Composite			Supplier	
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		leat †				<u> </u>	Countersink	-	Mislabe			$\boldsymbol{\vdash}$	ositioned V		— ₁₋ ,
	_			Strip in	Tube	<u> </u> _	Cut Too Short	<u> </u>	Misread	d		P(ower Loss/	Surge	Other
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ļ	_	· 1		aves in E	xtrusio	n	Drawing	<u> </u>	-i	Calibration		_			
L		Гurniի	g Se	quence			Finish		Out of S	Sequence					

Outside Dimensions

H:/FORMS/Quality Assurance\approved QA/NCRWO Rev G

Wave/Twist in Tube

Folio

DART AEROSPACE LTD	Work Order:	100597
Description: Window Assembly	Part Number:	D3136-043
Inspection Dwg: D3136 Rev: E		Page 1 of 1

	FIRS	T ARTICLE IN	NSPECTI	ON CHE	CKLIST		
	Х	First Arti	cle	Prot	otype		
Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Co	mments
21.00	+/-0.030	21.00"	_		+	Jamo	· (a
25.75	+/-0.030	25.75"	_	***************************************	<u> </u>		
26.25	+/-0.030	26.25"	_		T		
			0 /	1			
easured by:	Jm .	Audited by:	SL		Prototype A	pproval:	N/A
Date:	13-5-2	Date:	13/05/	03		Date:	N/A
Rev Date	Change				Rev	ised by	Approve

Rev	Date	Change	Revised by	Approved
Α	07.10.19	New Issue	KJ/EC/DD	X

	-										DQA:	Date	:
NCR: Y	'es /	No				WORK ORDER NON-C	ONFO	ORIV	IANCE / UPDATE		QA Closed:	Date	::
Work Order:						DISPOSITION AGAINST			GAINST DEP	DEPARTMENT/PROCESS			
Part No. NCR No.						Rework Scrap Use-as-is Work Order Update	Skid-tube Crosstube Machining Small Fab Thermoforming Finishing Large Fab Composite			nall Fab nishing	Water Jet Prod. Eng. Coor. Rec/Store/Packaging Supplier		Engineering Quality Other
Root	T				Descri	ption of work order update	Initia	al	Action	,	Sign &		
Cause	[ate	Step	Qty		or Non-conformance	Chief I	Eng	Description	1	Date	Verification	QC Inspector
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		Centre Not Concentric to O/S				BOM/Route	$\boldsymbol{\vdash}$	Hardware 			Over/Under Part Incorred	⊢	Weld
	—	Cracks				Broken/Damaged	 	Inspection Incomplete			Part Incorrect Part Lost/Mi	⊢ -	Wrong Stock Pulled
	Crushed/Crimped.				-	Burrs	\vdash	Instructions Incomplete/Unclear			Part Moved	22111R F	
	—	Cuffs				Contamination		Maintenance			Positioned V	Vrong	
	_	Heat Treat				Countersink Cut Too Short	<u> </u>	Mislabeled			Power Loss/		Other
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	Ripples in Bend				_ ⊢	4	\vdash	Offset Out of Calibration			***		
	Turning Sequence				'' 	Drawing	\vdash	Out of Sequence					
	Turning Sequence					Finish	\vdash	Outside Dimensions					

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